

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: SLIDE BAR		
Job Number	44842			Part Number	: D30111		
Estimate Number	11085			Drawing Number	: D3011 REV A		
P.O. Number	:			Project Number	: N/A		
This Issue	15/01/2009	S.O. No.	:	Drawing Revision	: A		
Prsht Rev.	NC			Material	:		
First Issue	11	Type	MACHINED PARTS			Due Date	30/01/2009
Previous Run	40938			Qty:	6	Um:	Each
Written By	:						
Checked & Approved By	JUL 09-01-15						
Comment	Est. C ~ 02.05.09 Added D6202 at step 2 NG Est Rev:D Added QC8 JLM Verified By:EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6202	I-Beam Extrusion	
		Comment: Qty.: 1.0000 f(s)/Unit Total : 6.0000 f(s) I Beam Extrusion Material: 6061-T6 (QQ-A-200/8) 'I' Beam Extrusion 4" x 2.796" x 0.326" Batch 37669	
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut Blanks: 26.57"	H.A 09/01/19
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	(P) 09/01/19
		Comment: HAAS CNC VERTICAL MACHINING #1 Ensure Batch Number programmed matches this W/O Machine as per folio FA129	JL/H.A 09/01/19
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	JL 09/01/20
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	88 09/01/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3011-1 PAR #: N/A Fault Category: Machining NCR: Yes No DQA: 18 Date: 09.a.29  
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 09/02/20

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/01/19	30	1 part scrapped due to wrong jaw(4) with different dimension R.C: Incorrect tooling.	Initial Chief Eng	The 4 jaw have been machined at the same thickness and will be identified to make sure it won't happen again	H.A 09/01/19	09.01.21	Assured	09.01.21
09/01/20	3.0	1 part scrapped lifted while machining: vibrated dimension 1.250 is under tolerance by 0.050"	Initial Chief Eng	> SCRAP + replace only 1 B37669	J.L 09/01/20	09.01.21	Assured	09.01.21
		R.C: previous set up by another shift had set up with different tool off sets, and when the 2nd side was machined, tools were run at zero offset. This resulted in a gap above the spacers causing lift & vibration.	Initial Chief Eng					

NOTE: Date & initial all entries ~~Set-up error~~.

Date: Thursday, 15/01/2009 11:24:26 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SLIDE BAR

Job Number: 44842

Part Number: D30111

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



*AWM 9-1-23*



*X6*

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0 POWDER COATING

POWDER COATING



*m109996*



*6*

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 8:30

OVEN TEMPERATURE: 320°

FINISH TIME: 9:00

*Fx 09/01/26*

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Am 09.01.26 ⑥*

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST137

*AS 09/01/27 ⑥*

10.0 QC21

FINAL INSPECTION/W/O RELEASE



*09/01/27 AS*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*Am 09.01.27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	44842
Description: Cappel slide bar	Part Number:	D3011-1
Inspection Dwg: D3011 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

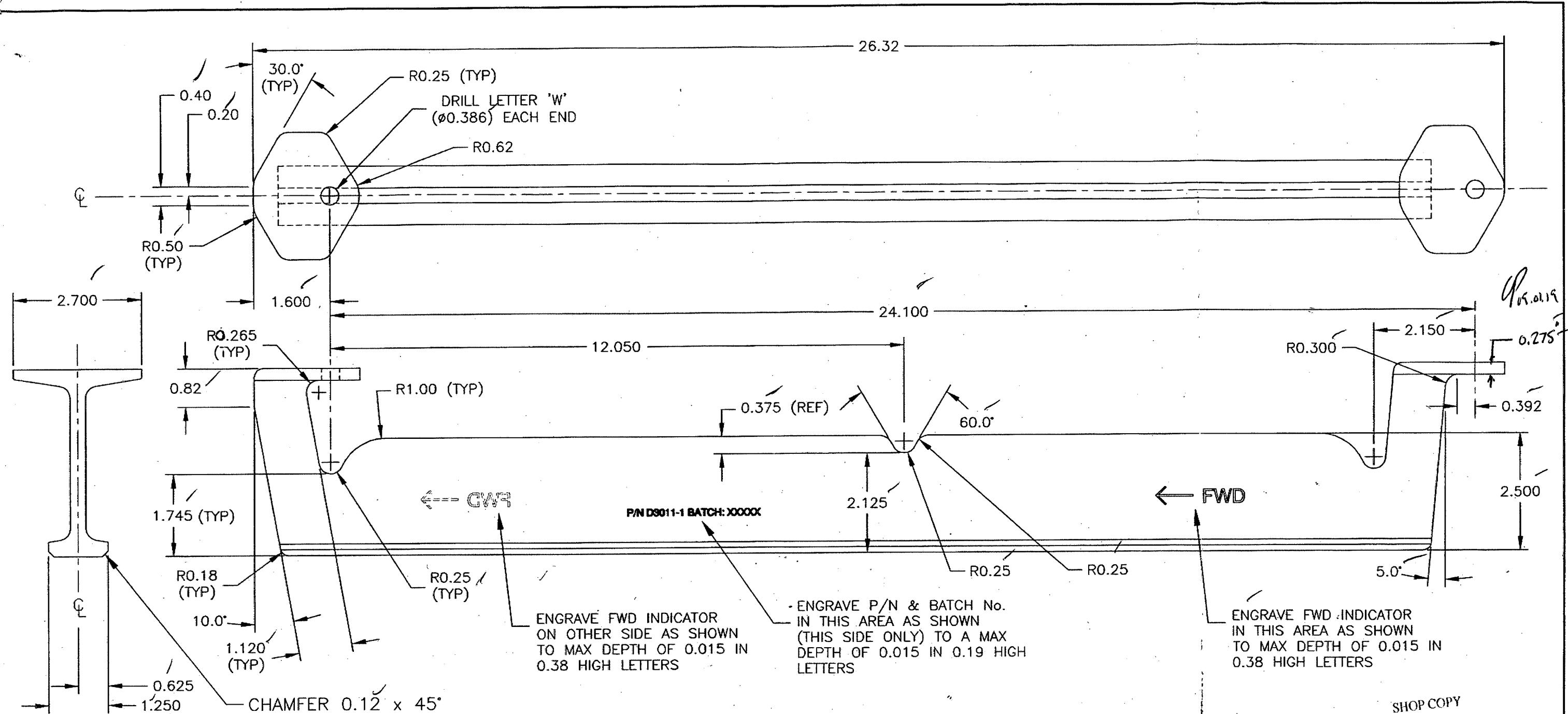
First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.700	$\pm .010$	2.702	✓			
1.250	$\pm .010$	1.251	✓			
.625	$\pm .010$	.623	✓			
.120x45°	$-.010 \quad +.5^\circ$	.125x45°	✓			
.386	$\pm .005$ $-.001$	.386	✓			
1.600	$\pm .010$	1.600	✓			
26.32	$\pm .030$	26.32	✓			
1.50	$\pm .030$	1.500	✓			
30°	$\pm .5^\circ$	30°	✓			
.275	$\pm .010$	.275	✓			
2.500	$\pm .010$	2.505	✓			
5°	$\pm .5^\circ$	5°	✓			
24.100	$\pm .010$	24.100	✓			
2.125	$\pm .010$	2.124	✓			
1.25	$\pm .030$	1.250	✓			
.375	$\pm .010$	.375	✓			
1.120	$\pm .010$	1.120	✓			
1.745	$\pm .010$	1.753	✓			
.82	$\pm .030$	.823	✓			
10°	$\pm .5^\circ$	10°	✓			

Measured by:	J.L	Audited by:	88	Prototype Approval:	N/A
Date:	09/01/20	Date:	09/01/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	





RELEASED  
01.04.09

04 COPY ISSUED

D3011-1

MANUFACTURE FROM D6202-027 EXTRUSION

BREAK ALL SHARP EDGES 0.010-0.020

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

A	01.03.29	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
DATE	1	REV. A
01.03.29		SHEET 1 OF 1
		SCALE
		1:2
		RAPPEL SLIDE BAR

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